

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017504**Date Inspected:** 07-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower & OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

TOWER JETTY

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 03 located on South Tower Manhole cover plate hinge DA3 – 5 – S. Welder is identified as 040365.

ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

Weld joint # 04 located on South Tower Manhole cover plate hinge DA3 – 5 – N. Welder is identified as 040365.

ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

MEASUREMENTS ON VERTICAL TRIAL ASSEMBLY TOWER LIFT-3&4

This QA Inspector carried out the measurements on South, East, West and North Tower locations exterior side of Lift – 3&4 to check faying surface between splice plate and the skin 'A', 'B', 'C', 'D' & 'E' and misalignment between two shafts as well. Measurements were recorded on the data sheet and submitted to the assigned task

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leader.

MEASUREMENTS ON VERTICAL TRIAL ASSEMBLY NORTH TOWER LIFT-3&4

This QA Inspector carried out dimensional verification inside North Tower to confirm the misalignment readings recorded between the longitudinal stiffeners of lift-3 & 4 on skin 'C' & 'D'. Measurements were recorded on the data sheet and submitted to the assigned task leader.

(See attached photos)

BAY#10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 07 located on Tower Façade ND1 – SFSA3 – 23. Welder is identified as 053829. ZPMC Quality Control (QC) Inspector is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

Weld joint # 08 located on Tower Façade ND1 – SFSA3 – 23. Welder is identified as 053829. ZPMC Quality Control (QC) Inspector is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 14B located on Lift-5 Bracket SD1 – BRSA5 – 1. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b.

Weld joint # 10B located on Lift-5 Bracket SD1 – BRSA5 – 1. Welder is identified as 041271. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b.

Weld joint # 07A located on Lift-5 Bracket SD1 – BRSA5 – 1. Welder is identified as 040614. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b.

Weld joint # 01A located on Lift-5 Bracket SD1 – BRSA5 – 1. Welder is identified as 040610. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b.

BAY#12

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#12

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This QA Inspector observed the following work in progress

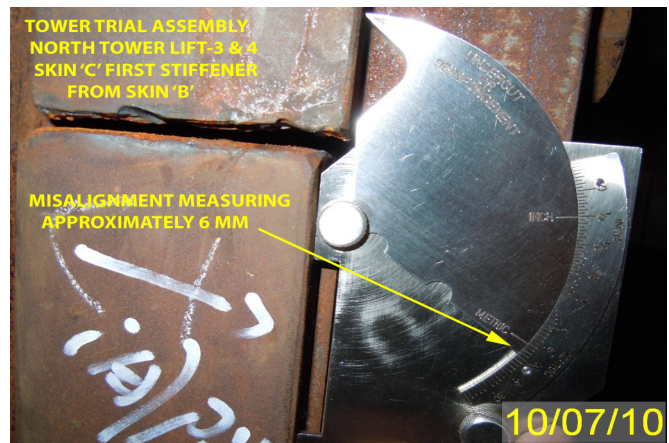
Fluxcored Arc Welding (FCAW):

Weld joint # 06 located on U-rib splice plate SA3114D – 006. Welder is identified as 059443. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

Weld joint # 02 located on U-rib splice plate SA3111A – 024. Welder is identified as 062265. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – Tc – U4b – F.

Weld joint # 06 located on U-rib splice plate SA3114D – 002. Welder is identified as 059443. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng - 15921845703, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer